

Work Order ID 86802

July-06-12 2:55:19 PM

86802

Page 1

Item ID: D3176-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Nut

Start Date: 7/06/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date: 12-07-09

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								DAS 04 9-89
D3176	Rev A								

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

13 - 3 - 10

4

DAS
04
9-89

Memo

1-Turn as per Folio FA286 & DWG D31762-Deburr

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

13 - 3 - 10

4

DAS
04
9-89

Memo

0.00

120

120

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

1- Mill flats as per dwg D31762- Deburr

NAT

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86802

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July-06-12 2:55:19 PM

Item ID: D3176-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut

Start Date: 7/06/12 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 8/24/12 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

140

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

D-A 13/03/11

DAS
08
08

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: ST 032 0.00

0.00

4x SP
B-3-12.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86802

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July-06-12 2:55:19 PM

Item ID:	D3176-3	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Nut						
Start Date:	7/06/12	Start Qty:	4.00	*4*	Cust Item ID:		
Required Date:	8/24/12	Req'd Qty:	4.00	*4*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC	QC21- Final Inspection - Work Order Release	0.00							13/3/12 JF
Quality Control	Memo	0.00							

13/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July-06-12 2:55:19 PM

Work Order ID: 86802

Parent Item: D3176-3

Parent Item Name: Nut

Start Date: 7/06/12

Required Date: 8/24/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Removed -1 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R1.000	Purchased	No				100	f	13.9822	0.05	0.2105264			
------------	-----------	----	--	--	--	-----	---	---------	------	-----------	--	--	--

303 Round Bar 1.00

Location	Loc Qty	Loc Code
MAT028	13.98215789	
120866	8.7	
121070	3.31515789	
121282	0.45	
121728	1.517	

13.3.10 DAS
04
9-89

124711

251

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	86802
Description: Nut	Part Number:	D3176-3
Inspection Dwg: D3176	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

Measured by:	✓ 04 9-89	Audited by:	b.a DAS 08 9-89	Prototype Approval:	N/A
Date:	13.3.16	Date:	13/03/11 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	TT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

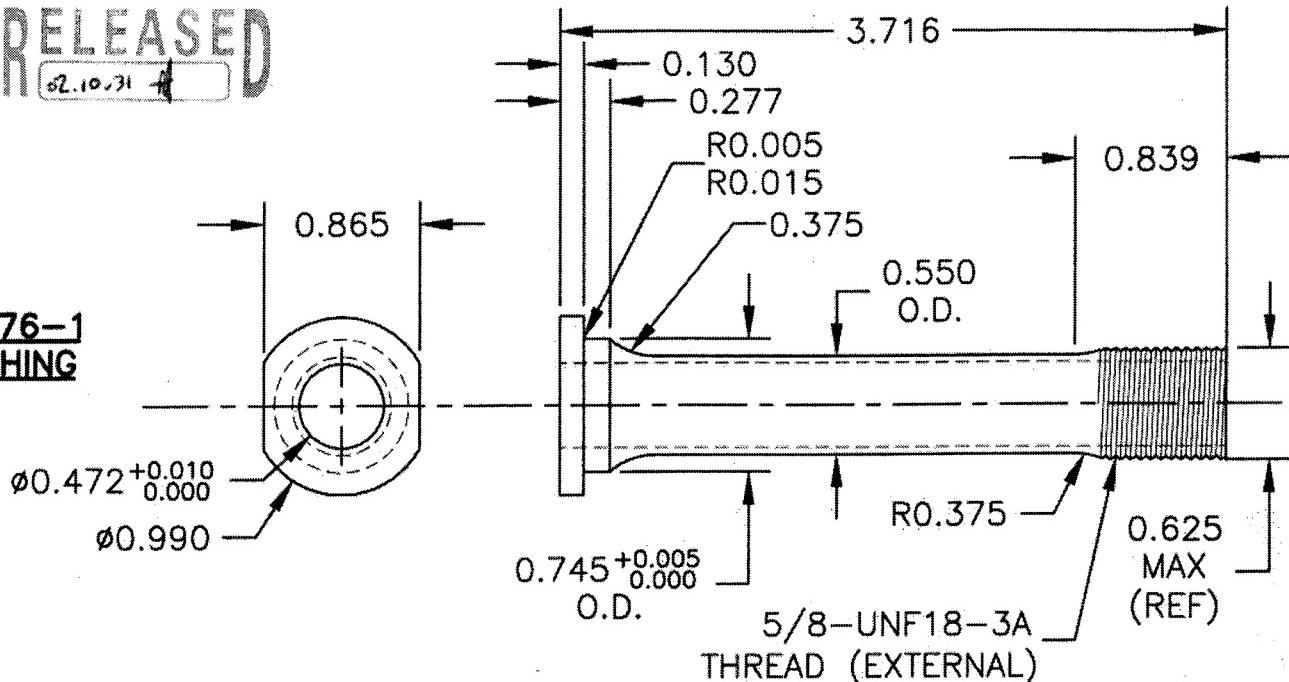
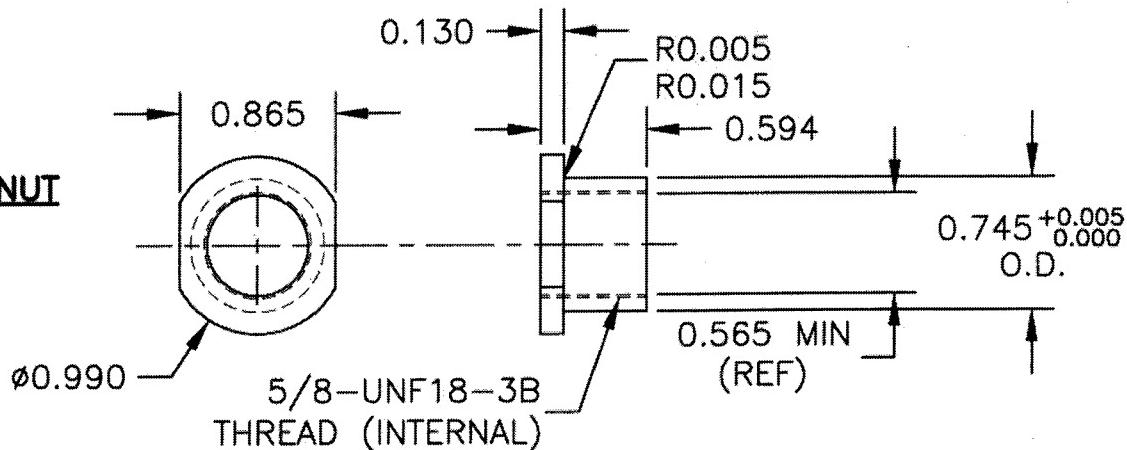
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN <i>RP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED
02.10.28**D3176-1
BUSHING****D3176-3 NUT****D3176-1/-3**

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

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